

Work Order ID 66766

Saturday, February 26, 2011 9:09:29 AM



~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4322-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Spacer

Stop



Start Date: 2/28/2011 Start Qty: 15.00



Cust Item ID:



Required Date: 3/3/2011 Req'd Qty: 15.00

Customer:

Reference:

11-02-26

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4322	<i>PAT 242 11-02-26 A 18</i>								
100		0.00							
	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Make as per Dwg and Folio FB039								
	2-Break all sharp edges 0.010 max.								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

11/2/28

11/2/28

*- inspect to Pat
Dry only
Sutcliffe*






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Item ID: D4322-1 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Spacer
Start Date: 2/28/2011 Start Qty: 15.00  Cust Item ID:
Required Date: 3/3/2011 Req'd Qty: 15.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>15</u>			
									= 7 m-l 11/02/28
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							15 BR 11-2-28.
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>Pool Shelf</u> Memo	0.00 0.00							15 Jm/11-03-01 RD1370 man. replk (2/13/11) (15)

Work Order ID 66766

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Item ID:	D4322-1	Accept		Setup	Start
Revision ID:	PRELIM				
Item Name:	Spacer			Stop	
Start Date:	2/28/2011	Start Qty:	15.00		
Required Date:	3/3/2011	Req'd Qty:	15.00		
Reference:					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start
	QC:	Date:	SPC (Y/N):	Date:	Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALLEFFECTIVE 11/02/11 AUTH LL
RELEASED WJ DATE 11/05/13

Picklist Print

Saturday, February 26, 2011 9:09:25 AM

Page 1

Work Order ID: 66766

Parent Item: D4322-1

Parent Item Name: Spacer



Start Date: 2/28/2011

Required Date: 3/3/2011

Start Qty: 15.00

Required Qty: 15.00

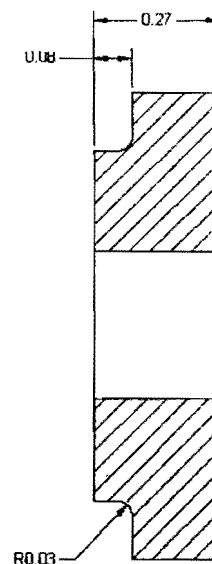
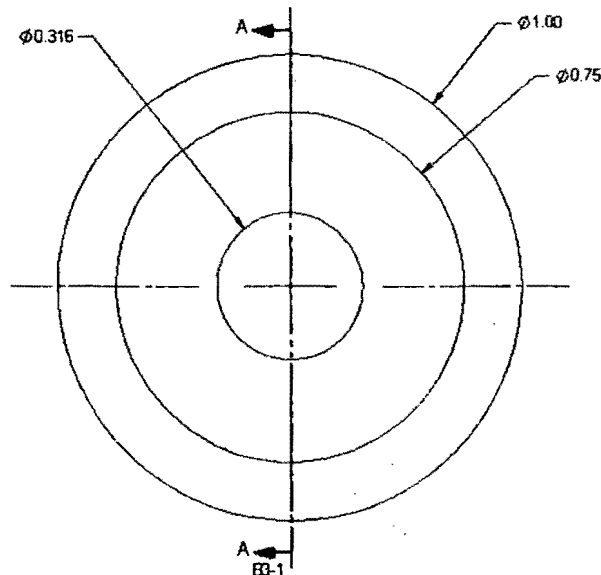
Comments: IPP REV:A NEW ISSUE 11-02-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit 0.0325	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			100	f	27.6140	0.0325	0.394737			
ROUND BAR 1.00"													

Location	Loc Qty	Loc Code
MAT	25.434	
115609	1.434	
116406	24	
MAT013	2.18	
108876	1.88	
113457	0.3	

11/2/25

- 5 RT



1.190

SECTION A-A
SCALE 4X

D4322-1 SPACER

PRELIMINARY ISSUE

11.01.13

NOTES

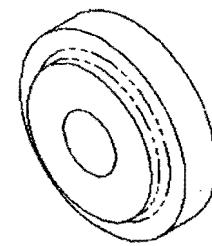
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
REF DART SPEC M6061T6R1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.01 lbs

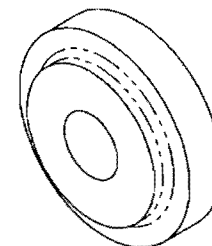
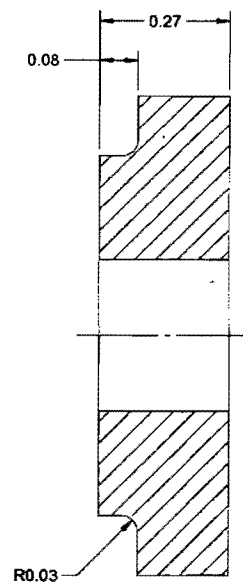
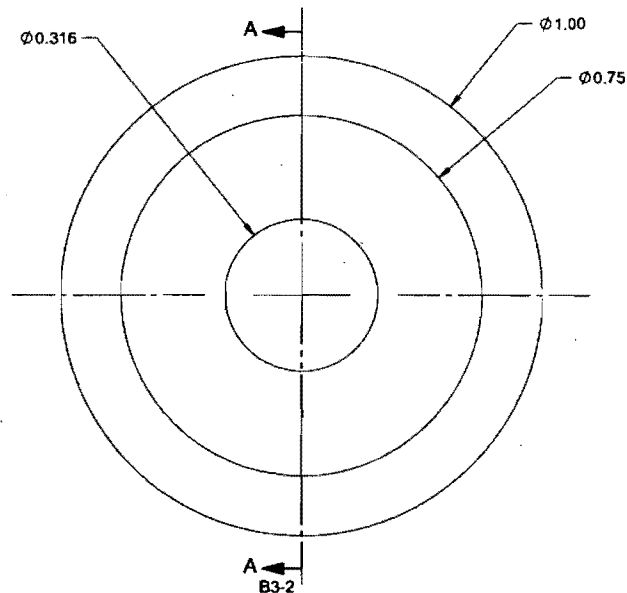
REV.	DESCRIPTION	BY	DATE
PA2	NEW ISSUE		11.01.13
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED	N/A		
DE APPR.	N/A		
DATE	11.01.13		

DART AEROSPACE LTD
HAMKESLURY, ONTARIO, CANADA
DRAWING NO. **D4322**
REV. PA2
SHEET 1 OF 2
TITLE **SPACER**
SCALE
NTS

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w/o 66766





D4322-1 SPACER

SECTION A-A
SCALE 4X B6-2

66766

RELEASED
2011-05-18

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR
REF DART SPEC M6061T6R1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4322	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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